

Work Order ID 52938

October 19, 2009 11:03:18 AM



Page 1

Item ID: D3992-4

Accept



Setup Start



Revision ID: A

Stop



Item Name: Reinforcement

Start Date: 10/19/09 Start Qty: 4.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *RL*

Date: *09-10-19*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3992

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3992

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

B 9-10-28

(6)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-10-28

SpA

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Page 2

Item ID: D3992-4

Accept

Revision ID: A

Item Name: Reinforcement

Start Date: 10/19/09 Start Qty: 4.00

Required Date: 11/02/09 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2) 8 09/10/09

6 6

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

8 09/11/04

6 6

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 8 09/11/05

6 6

Work Order ID 52938

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Page 3

Item ID: D3992-4

Accept

Setup Start

Revision ID: A

Stop

Item Name: Reinforcement

Start Date: 10/19/09 Start Qty: 4.00

Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging



Handwritten: 09/11/10

Handwritten: (X) COUNTED

Handwritten: Ump 09/11/10

Handwritten: X

Handwritten: 9/11/10

Handwritten: (X) SP

Work Order ID 52938

October 19, 2009 11:03:18 AM



Page 4

Item ID: D3992-4

Accept



Setup Start



Revision ID: A

Stop



Item Name: Reinforcement

Start Date: 10/19/09 Start Qty: 4.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/11

MF
09-11-10

Picklist Print

October 19, 2009 11:03:22 AM

Page 1

Work Order ID: 52938

Parent Item: D3992-4

Parent Item Name: Reinforcement


Start Date: 10/19/09

Required Date: 11/02/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	284.9347	0.9735	1.5		
												
6061-T6 .080 Sheet												

B 9-10-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

284.9347

107904

0.02

110254

2.5

110630

38.0926

112040

0.0437

112141

33

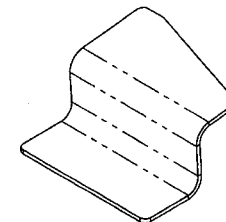
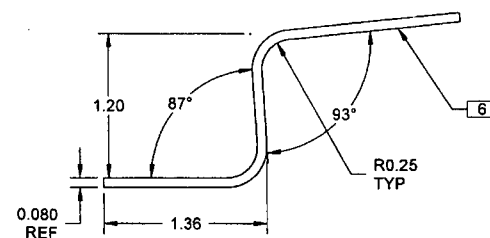
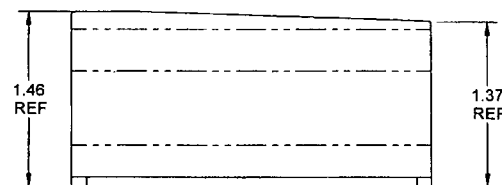
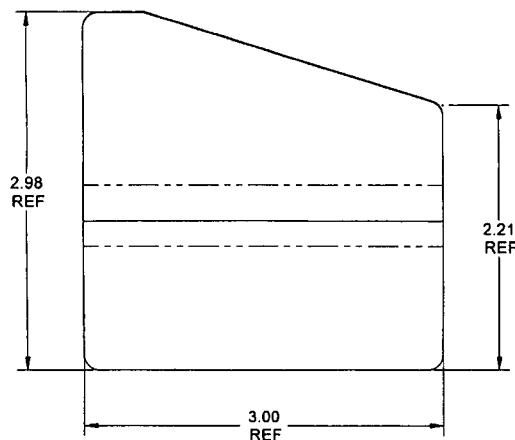
112512

19.2784

112763

192

112763



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NO. *RF 09-10-19*
52938

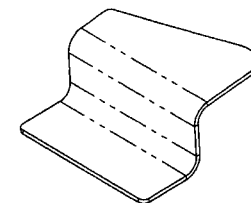
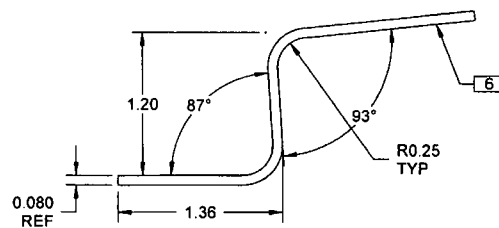
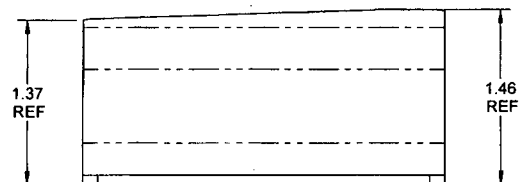
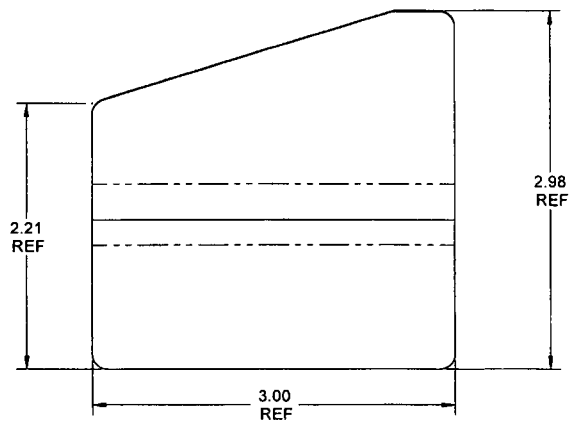
D3992-1 REINFORCEMENT
MADE FROM D3992-1F

RELEASE
2009-10-08
MD

NOTES:

- 1) MATERIAL: MADE FROM D3992-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3992-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

A NEW ISSUE		BY <i>JS</i> DATE 09.09.28	
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JS</i>		
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D3992	SHEET 1 OF 6
APPROVED	<i>JS</i>	TITLE	SCALE
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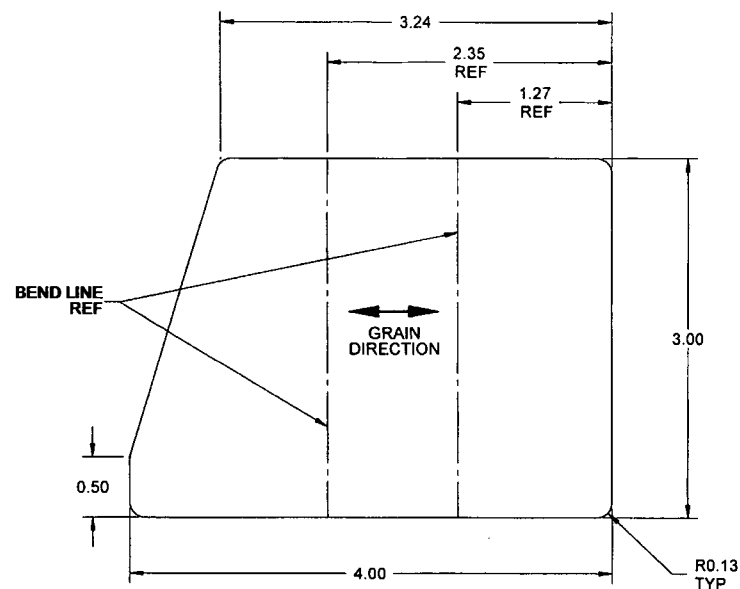
D3992-2 REINFORCEMENT
MADE FROM D3992-1F

RELEASED
2009-10-08
JND

NOTES:

- 1) MATERIAL: MADE FROM D3992-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3992-2" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

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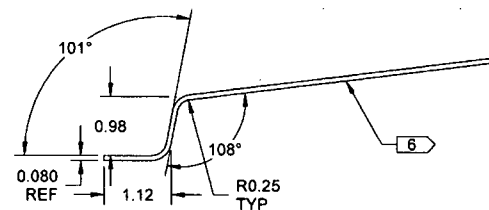
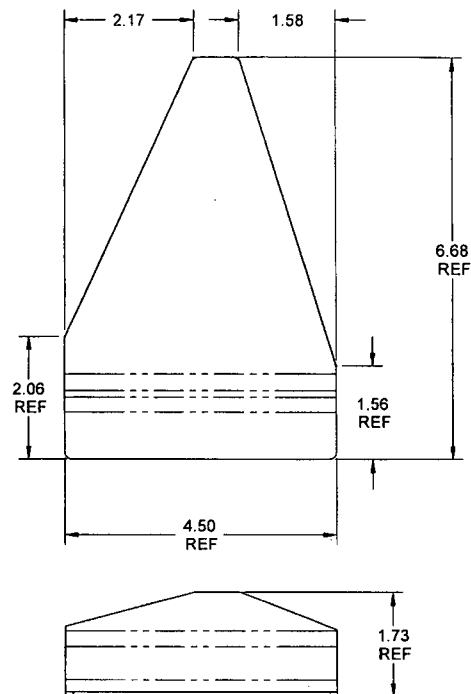
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NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

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D3992-3 REINFORCEMENT
MADE FROM D3992-3F

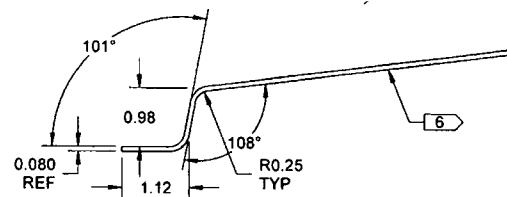
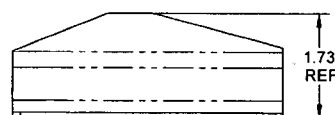
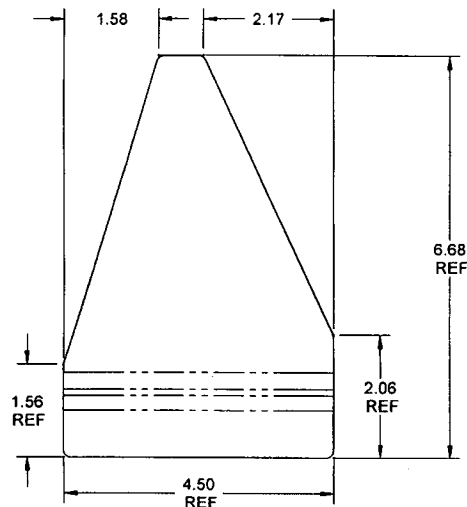
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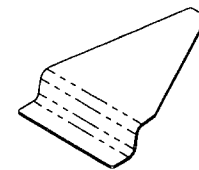
NOTES:

- 1) MATERIAL: MADE FROM D3992-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3992-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs

DESIGN	<u>AS</u>	DART AEROSPACE LTD	
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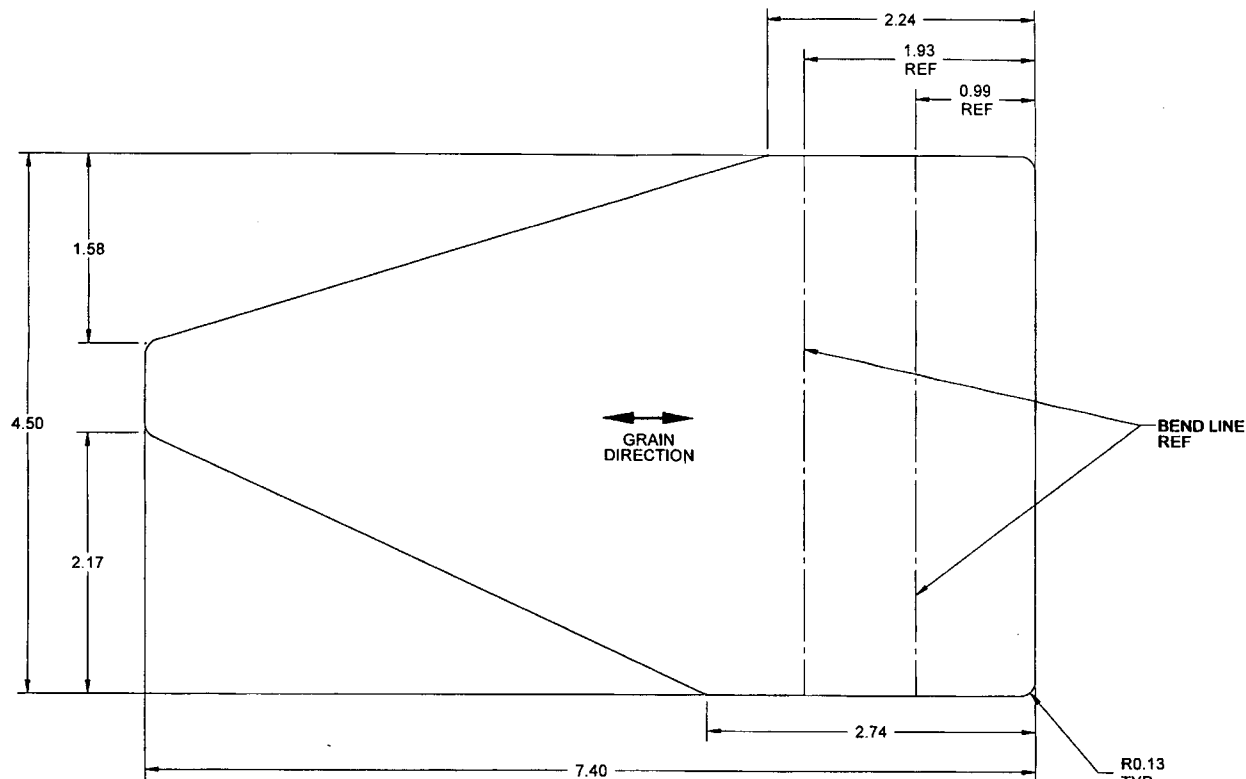


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- NOTES:
- 1) MATERIAL: MADE FROM D3992-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3992-4" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.07 lbs

DESIGN	<i>AS</i>	DART AEROSPACE LTD	
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D3992-3F REINFORCEMENT FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.080
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

DESIGN	<u>AS</u>	DART AEROSPACE LTD	
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